

Work Order ID 154923

Tuesday, January 03, 2017 3:26:13 PM

154923

Page 1

Item ID: D3574-5

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Cabin Floor Protector

Start Date: 1/9/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/16/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: DAS 21 Date: JAN 04 2017

Tooling:

Date:

Run Start

NR1QC: 9-89

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3574	Rev B								

100

0.00

100

Waterjet

FLOW WATER JET

Memo

0.07

FLOW CNC Waterjet

1-Cut as per Dwg D3574 Dwg Rev: B Prog Rev: B 2-
Deburr if necessary(1)on 17/01/06

110

0.00

110

QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

(1)on 17/01/06

120

0.00

120

QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

1DAS 38
JAN 11 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐		☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design ☐	☐	Operator ☐		☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data ☐	☐	Offset/Setup ☐		☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling ☐	☐	Supplier ☐		☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre ☐	☐	Training ☐		☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material ☐	☐	Use for Testing ☐		☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport ☐	☐	Poor Information ☐		☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge ☐	☐	Rushing ☐		☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA ☐	☐	Product Improvement ☐		☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation ☐	☐	Process Improvement ☐		☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date ☐	☐	Manufacturing Process ☐		OTHER : _____							
Misidentified ☐	☐	Past Due ☐									

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Page 2

Item ID: D3574-5 **Accept** ***N900040100*** **Setup Start *NS1***
Revision ID: **Stop *NS2***
Item Name: Cabin Floor Protector
Start Date: 1/9/2017 **Start Qty:** 1.00 ***1*** **Cust Item ID:**
Required Date: 1/16/2017 **Req'd Qty:** 1.00 ***1*** **Customer:**
Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start *NR1***
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Small Fab Small Fab	Small Fab Memo Deburr if necessary.	0.00 0.00 9-89							
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: 15002 Memo	0.00 0.00				1			DAS 6 1-89 JAN 13 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:12.5%;">Skid-tube ☐</td> <td style="width:12.5%;">Cross tube ☐</td> <td style="width:12.5%;">Water Jet ☐</td> <td style="width:12.5%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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N900040100

Setup Start *NS1*

Stop *NS2*

Stop *NS2*

Start Date: 1/9/2017 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 1/16/2017 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Operation Description

Set Up/ Run Hours

Tool ID

Tool #**Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number**Insp.
Stamp**

160

QC21- Final Inspection - Work Order Release

0.00

160

0.02

QC

Memo

Quality Control

DAS
21
9-89

JAN 16 2017

MF
17-1-13

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

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Parent Item: D3574-5

D3574-5

Parent Item Name: Cabin Floor Protector

Start Date: 1/9/2017

Required Date: 1/16/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev :A New Issue 07.07.23 EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No				sf	4,098.452		25.35294			

MI FXS 125-F60029-04

GE PLASTICS LEXAN SHEET (DARK GREY)

on 17/01/06

Location

Loc Qty

Loc Code

MAT018

4098.452353

m135074

799.682353

m136228

3298.77

26

DQA: _____ Date: _____



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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																								
Description Work Order Deviation				Disposition				Completed By																																																							
								Lead hand / Supervisor Approval Verification																																																							
								QC / QA Coordinator Approval																																																							
Root Cause		FAULT CATEGORY																																																													
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	No Re-verification ☐	Operator ☐	Offset/Setup ☐	Supplier ☐	Training ☐	Use for Testing ☐	Poor Information ☐	Rushing ☐	Product Improvement ☐	Process Improvement ☐	Manufacturing Process ☐	Past Due ☐	Pressure/Forced ☐	Bending ☐	Centre Not Concentric ☐	Cracks ☐	Crimp/Kink/Ripple/Wave ☐	Cuffs ☐	Crushing ☐	Heat Treat ☐	Wave/Twist in Tube ☐	Marks/Chatter ☐	Temperature/Cure ☐	Set-up ☐	BOM/Route ☐	Broken/Damage/Defect ☐	Inspection Incomplete/Unqualified ☐	Contamination ☐	Countersink ☐	Cut Too Short ☐	Instructions Incomplete/Unclear ☐	Drill Holes ☐	Power Loss/Surge ☐	Folio/Program ☐	Grain ☐	Weld ☐	Wrong Stock Pulled ☐	Out of Sequence ☐	Off-set ☐	Mislabeled ☐	Fit/Function ☐	Misaligned/off center ☐	Positioned Wrong ☐	Outside Dimensions ☐	Over/Under tolerance ☐	Part Incorrect ☐	Part Lost/Missing ☐	Part Moved ☐	Drawing ☐	Finish ☐	Misread ☐	Turning Sequence ☐
																								OTHER :																																							

DART AEROSPACE LTD		Work Order:	154923
Description: Cabin Floor Protector		Part Number:	D3574-5
Inspection Dwg: D3574 Rev: B		Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	Ø 3.00	/		Viper-02	
7.37	+/-0.030	7.37	/		Tap	
11.00	+/-0.030	11.00	/			
15.25	+/-0.030	15.25	/			
25.87	+/-0.030	25.87	/			
39.75	+/-0.030	39.75	/			
44.75	+/-0.030	44.75	/			
49.11	+/-0.030	49.11	/			
51.11	+/-0.030	51.11	/			
1.75	+/-0.030	1.75	/			
58.38	+/-0.030	58.38	/			
63.50	+/-0.030	63.50	/			
65.25	+/-0.030	65.25	/			
11.87	+/-0.030	11.87	/			
14.75	+/-0.030	14.75	/			
26.00	+/-0.030	26.00	/			
40.87	+/-0.030	40.87	/			
45.00	+/-0.030	45.00	/			
48.00	+/-0.030	48.00	/			
55.13	+/-0.030	55.13	/			
58.38	+/-0.030	58.38	/			
61.25	+/-0.030	61.25	/			
61.88	+/-0.030	61.88	/			
64.63	+/-0.030	64.63	/			
7.63	+/-0.030	7.63	/			
11.00	+/-0.030	11.00	/			
22.50	+/-0.030	22.50	/			
35.13	+/-0.030	35.13	/			
36.50	+/-0.030	36.50	/			
40.00	+/-0.030	40.00	/			
41.88	+/-0.030	41.88	/			
43.63	+/-0.030	43.63	/			
6.75	+/-0.030	6.75	/			

DART AEROSPACE LTD		Work Order: 154923
Description: Cabin Floor Protector		Part Number: D3574-5
Inspection Dwg: D3574	Rev: B	Page 2 of 2

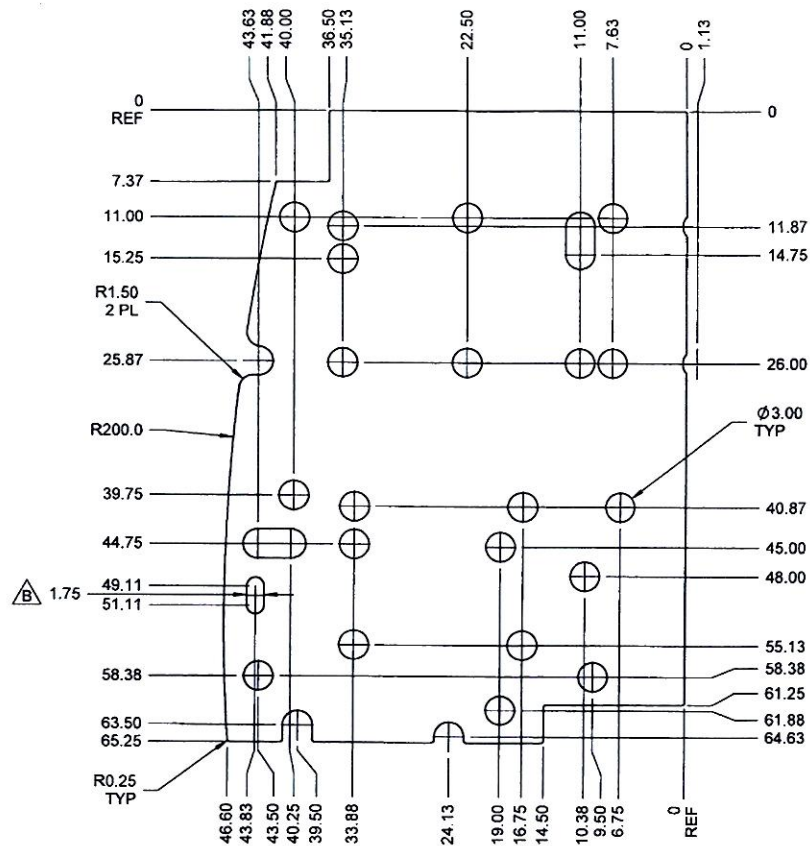
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
9.50	+/-0.030	9.50	'		Tape	
10.38	+/-0.030	10.38	'		Viper-02	
14.50	+/-0.030	14.50	'			
16.75	+/-0.030	16.75	'			
19.00	+/-0.030	19.00	'			
24.13	+/-0.030	24.13	'			
33.88	+/-0.030	33.88	'			
39.50	+/-0.030	39.50	'			
40.25	+/-0.030	40.25	'			
43.50	+/-0.030	43.50	'			
43.83	+/-0.030	43.83	'			
46.60	+/-0.030	46.60	'			
0.125	+/-0.010	0.125	'			

Measured by: DC	Audited by: DAS 38	Prototype Approval:	N/A
Date: 17/01/06	Date: 9-89 JAN 11 2017	Date:	N/A

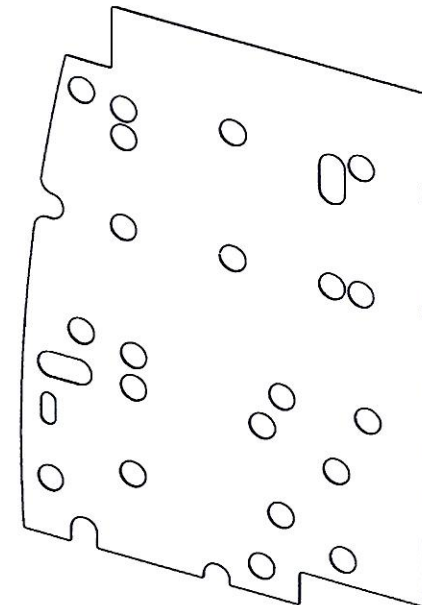
Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/DD	
B	08.07.31	1.13 dimension removed	KJ/DD	
C	09.05.15	Dimensions updated per Dwg Rev B	KJ	



D3574-5 CABIN FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-5" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.38 lbs
- 8) CHECK PER TEMPLATE DT8964



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WITHOUT NOTICE
WORK ORDER
NO. 154923 MLCJ
1701-04

RELEASED
01/04/07 JAB

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3574	REV. B
MFG. APPR.			SHEET 5 OF 6
APPROVED		TITLE	SCALE
DE APPR.		CABIN FLOOR PROTECTOR	NTS
DATE	09.03.25	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR REPRODUCED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	